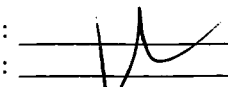
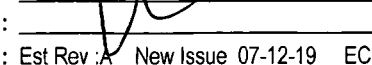


Date: Wednesday, 19/12/2007 10:10:32 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36446
 Estimate Number : 13107
 P.O. Number : N/A
 This Issue : 19/12/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By : 
 Checked & Approved By : 
 Comment : Est Rev : A New Issue 07-12-19 EC

Drawing Name : WEARPLATE

Part Number : D3719041
 Drawing Number : D3719 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material : N/A
 Due Date : 20/12/2007

Qty: 21 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.5933 sf(s)/Unit Total : 2.3730 sf(s)
 304/316 .063 Sheet 0.080
 Batch: 105997

HB 07-12-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3719
 Dwg Rev: A
 Prog Rev: A

HB 07-12-19

(2)

2-Deburr if necessary

HB 07-12-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 07-12-19

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



HB 07-12-19 (2)

Comment: SECOND CHECK

5.0 D30093 CUP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
 CUP
 Batch: 036431

FC 07/12/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.12.19	✓	USE 304/316 SS SHEET 0.080" THICK N/A CP → USED 0.063 07.12.20				CP 07.12.19 Pw 08/042		
07.12.20	6.5	DRILL HOLES IN COP 17/64" (Ø0.266) TYP 4 PLACES				CP 07.12.20 Pw 08/042		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 15 Date: 08/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/12/2007 10:10:32 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36446

Part Number: D3719041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3719

2-Weld hard facing as per Dwg D3719

A/R 2059B Hard Coat rod

Batch: M106390

7.0

QC9

VISUAL WELDING INSPECTION



ENGINEER
APPROVAL



Comment: VISUAL WELDING INSPECTION

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 497

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 07.12.19 AUTH U

RELEASED U DATE 07.01.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

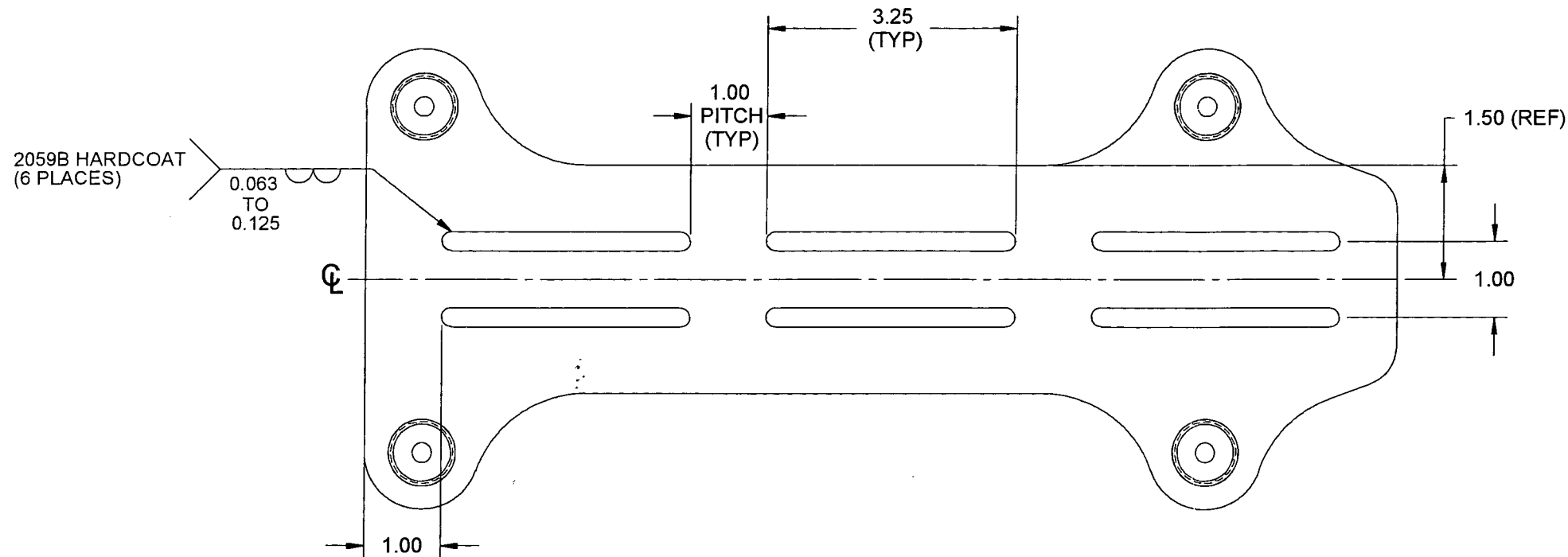
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

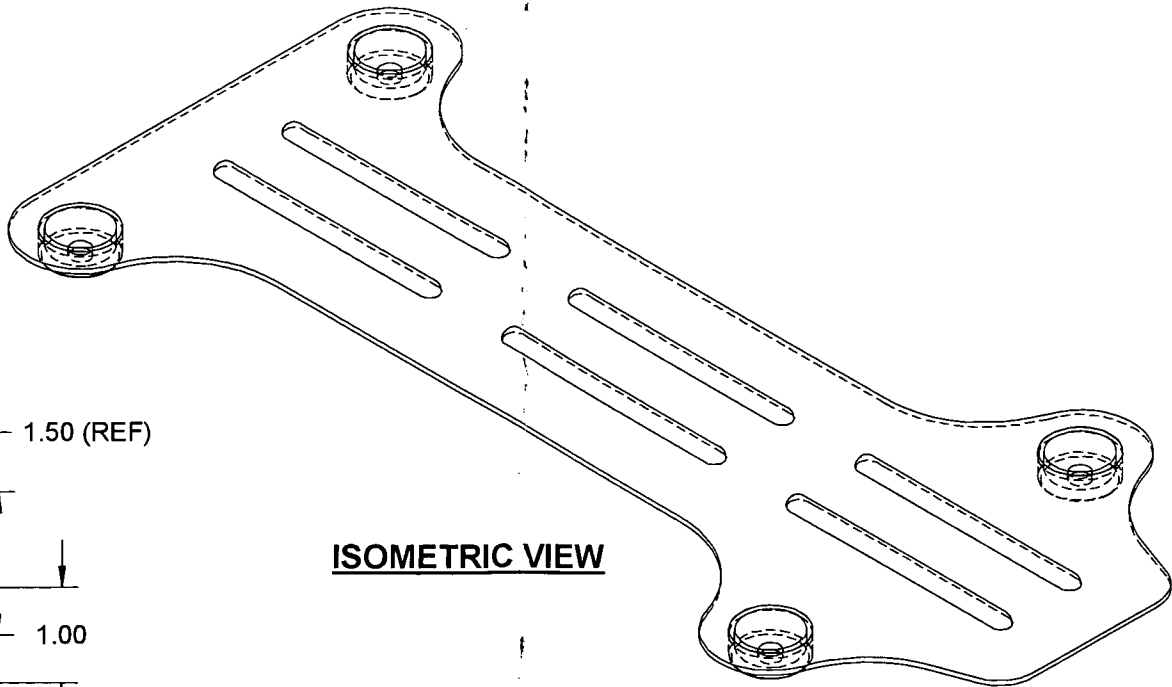
NOTE: Date & initial all entries

D3719-041 PARTS LIST:			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3719-1	WEARPLATE	1
2	D3009-3	CUP	4



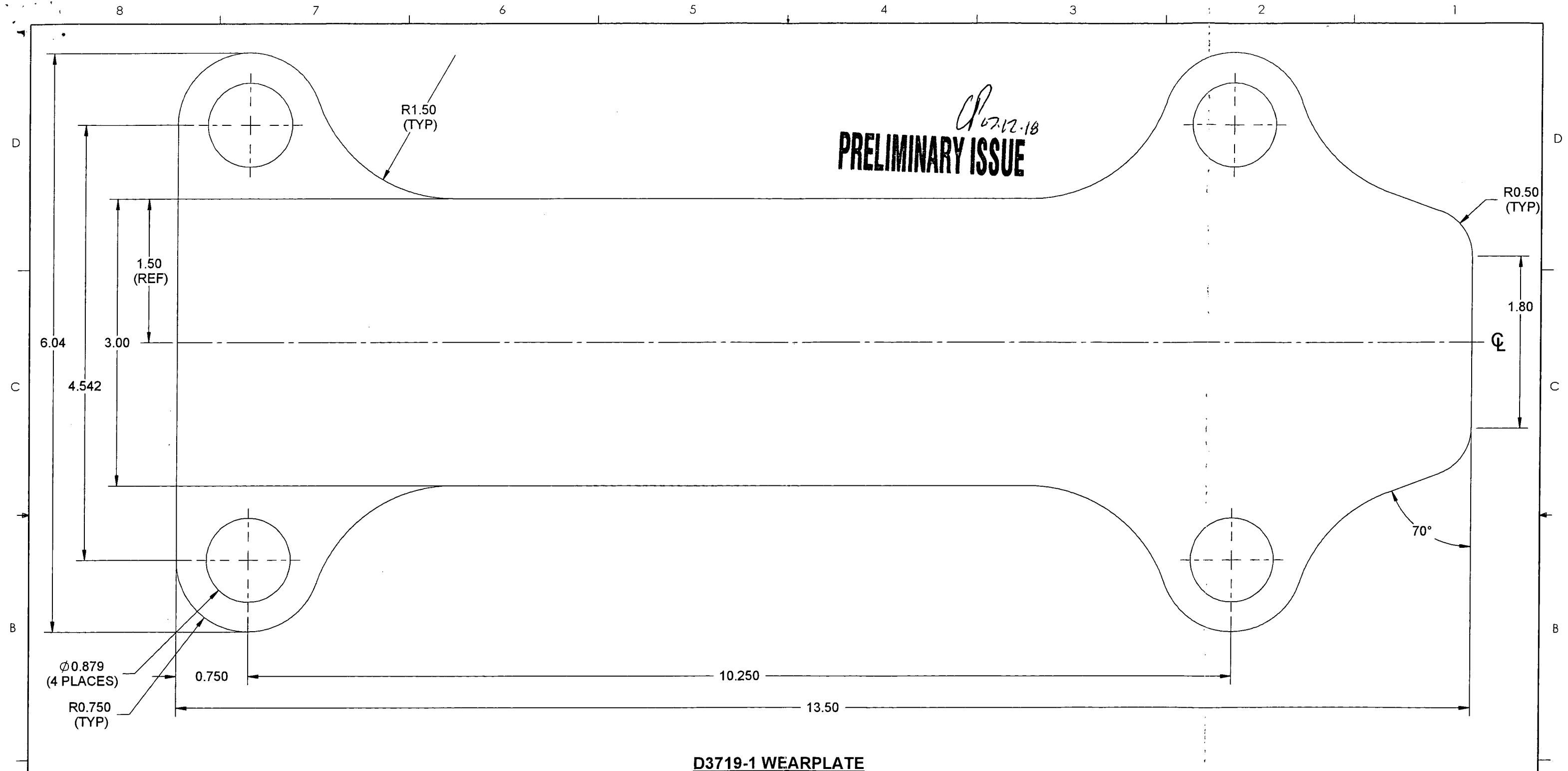
D3719-041 WEARPLATE

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004



PRELIMINARY ISSUE 07.12.18

A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3719	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:2
DATE	07.12.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



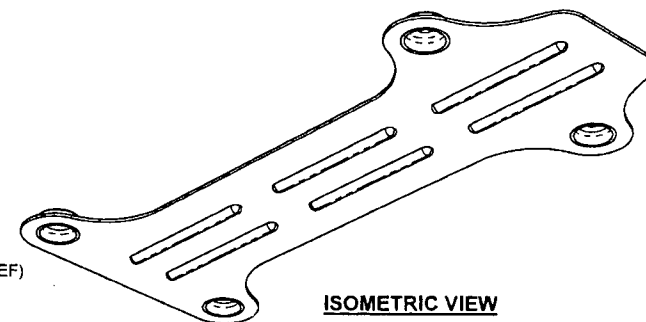
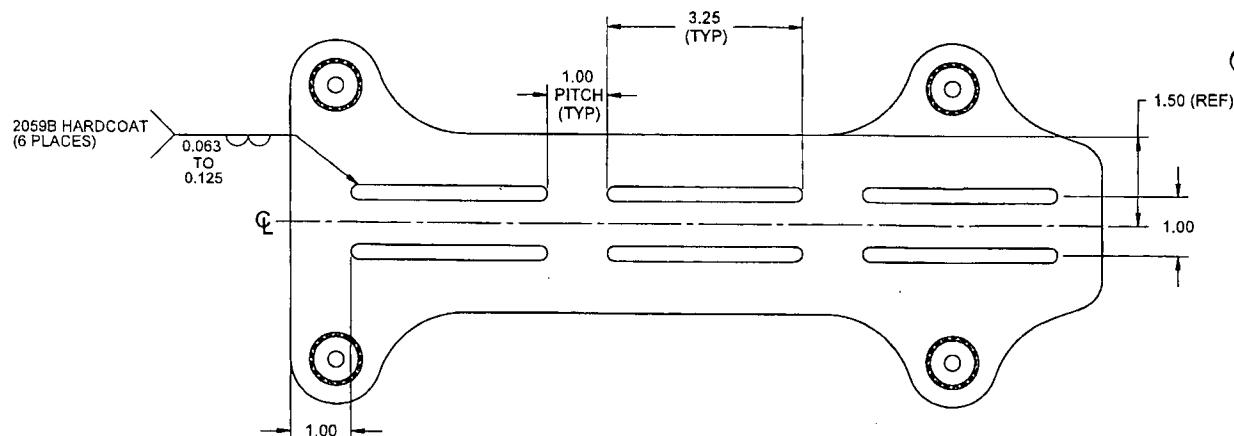
D3719-1 WEARPLATE

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-1" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.38 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE

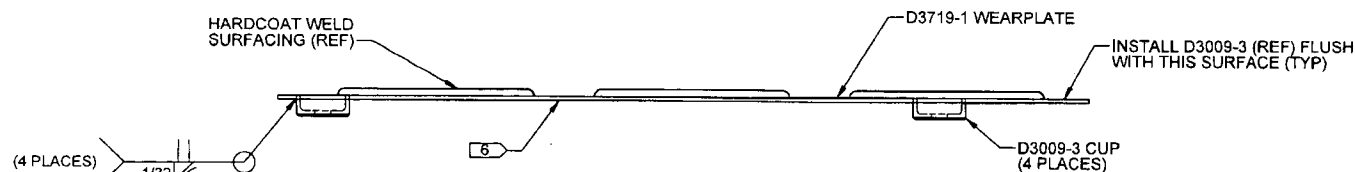
DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3719	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:1
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PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



ISOMETRIC VIEW

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36496



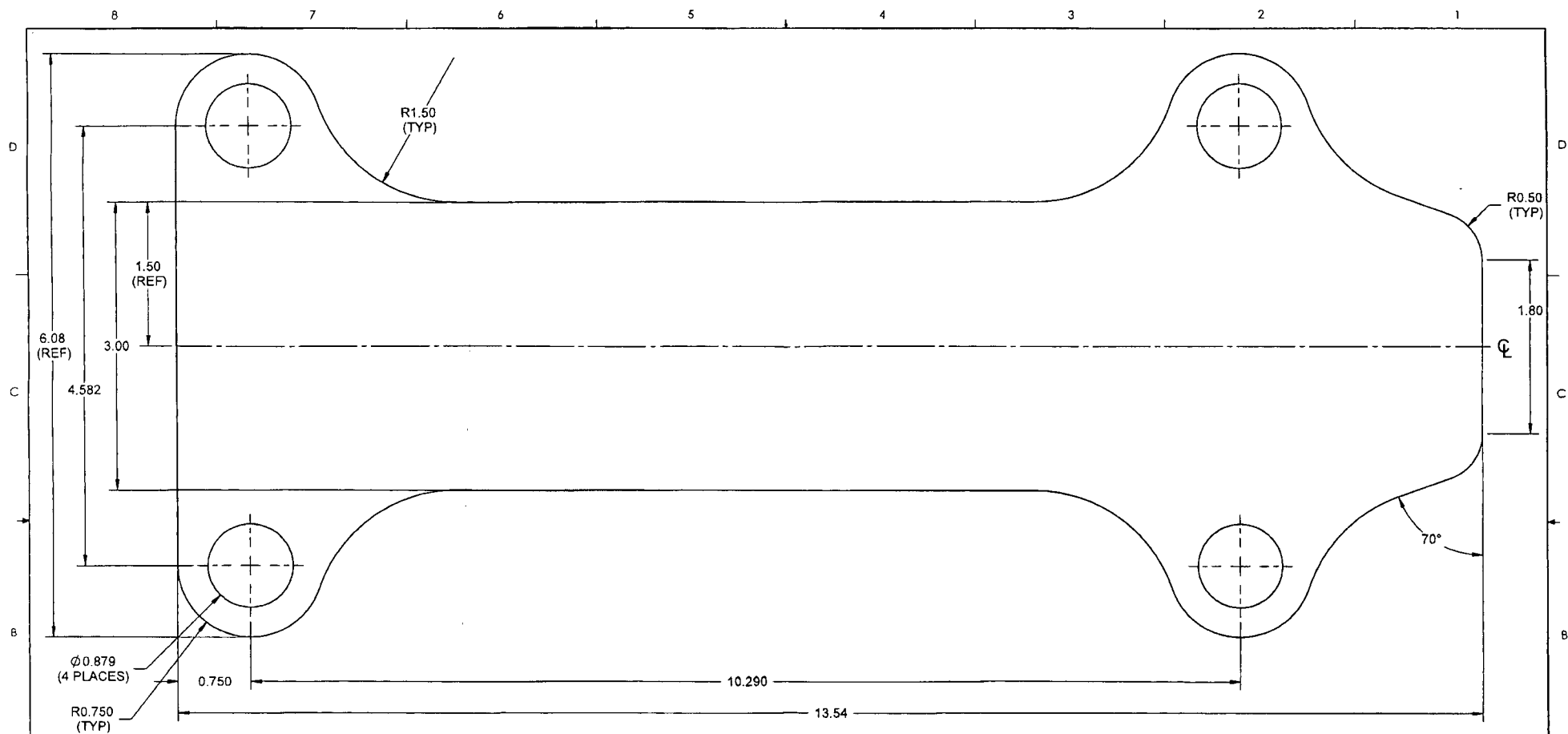
D3719-041 WEARPLATE

RELEASED
07-01-07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WELD PER DART QSI 004

A	NEW ISSUE		CP	07.12.12
REV.		DESCRIPTION	BY	DATE
DESIGN	g3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3719 TITLE WEARPLATE COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	g3			
CHECKED	g3			
MFG. APPR.	g3			REV.
APPROVED	g3			SHEET 1 OF
DE APPR.	g3			SCALE
DATE	07.12.12			1.



D3719-1 WEARPLATE

RELEASED
04.07.07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 36446

DESIGN	91	DART AEROSPACE LTD	
DRAWN	91	HAWKESBURY, ONTARIO, CANADA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3719	SHEET 2 OF 2
APPROVED	91	TITLE	SCALE
DE APPR.	91	WEARPLATE	1:1
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